

Date: Thursday, 7/19/2007 2:20:22 PM  
 User: Kim Johnston

## Process Sheet

|  |                                     |
|--|-------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WEARSHOE             |
| Job Number : 33629                             |                                     |
| Estimate Number : 12729                        |                                     |
| P.O. Number : N/A                              | Part Number : D353539               |
| This Issue : 7/19/2007 S.O. No. : N/A          | Drawing Number : D3535 UNDER REVIEW |
| Prsht Rev. : NC                                | Project Number : N/A                |
| First Issue : N/A                              | Drawing Revision : B                |
| Previous Run : 33440                           | Material : N/A                      |
| Written By : <u>[Signature]</u>                | Due Date : 8/3/2007                 |
| Checked & Approved By : <u>[Signature]</u>     | Qty: 20 Um: Each                    |
| Comment : Est Rev:A New Issue 07-02-15 JLM     |                                     |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | M304S20GA | 304/316 .040 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 0.9986 sf(s)/Unit Total : 19.9710 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: M105061 HB 07-07-21

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

HB 07-07-21

20

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-07-21

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

EP 07/07/23

20

|     |          |          |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

Identify as D3535-41

Form Joggle on brake using Jig DT8158 as per Dwg D3535

FF 07-07-23

FF 07-07-24

20

20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 07/07/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:20:22 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 33629

Part Number: D353539

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/24 (20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BE/m.d 07-07-25

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 07/07/25 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-16 : m.d 07/07/25

(20X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/25

Job Completion



Final

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

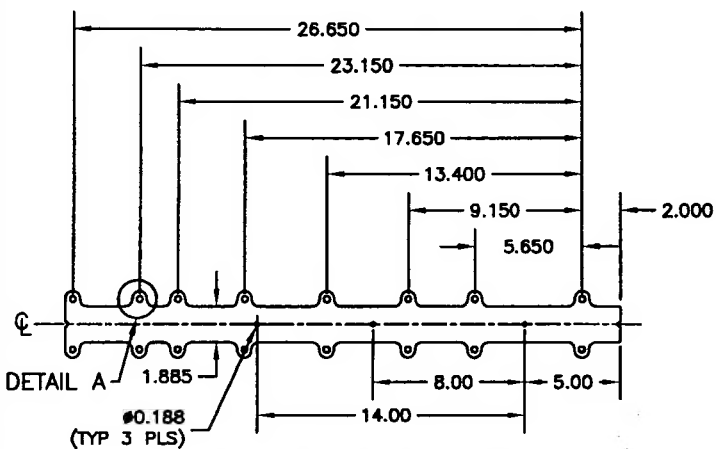
**NOTE:** Date & initial all entries

**DART**

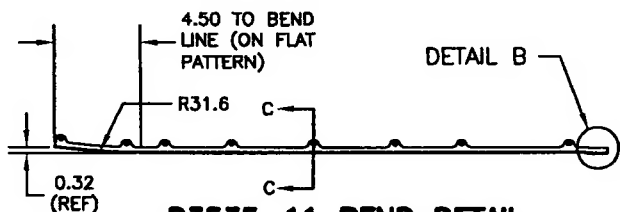
RELEASED

07.04.24

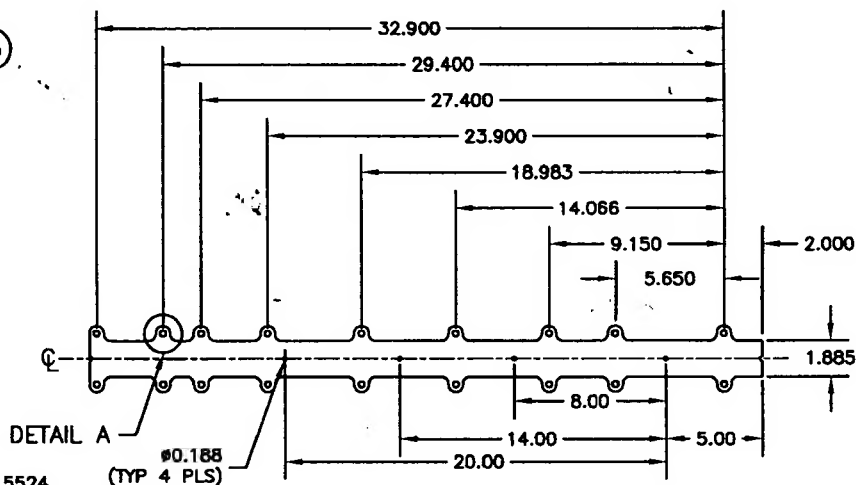
| DESIGN   | DRAWN BY | DART AEROSPACE USA, INC.        |
|----------|----------|---------------------------------|
| CB       | PH       | PORT HADLOCK, WA                |
| CHECKED  | APPROVED | DRAWING NO.                     |
|          |          | D3535                           |
| DATE     |          | TITLE                           |
| 07.04.17 |          | WEARSHOE                        |
|          |          | SCALE                           |
|          |          | 1:10                            |
| A        | 06.10.25 | NEW ISSUE                       |
| B        | 07.04.17 | MOVE TAB OUTBOARD, ADD AMS SPEC |



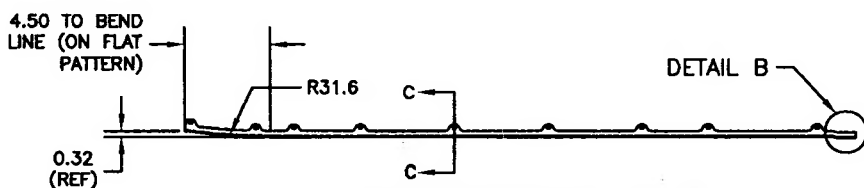
**D3535-11F FLAT PATTERN**



**D3535-11 BEND DETAIL**



**D3535-13F FLAT PATTERN**





**D3535-13 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 32629

RELEASED

|  |   |   |                        |
|--|---|---|------------------------|
| DESIGN<br><b>CB</b>  | DRAWN BY<br><b>PH</b>   | <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA |                        |
| CHECKED<br> | APPROVED<br> | DRAWING NO.<br><b>D3535</b>                         | REV. B<br>SHEET 2 OF 7 |
| DATE<br><b>07.04.17</b>  | TITLE<br><b>WEARSHOE</b>  |   | SCALE<br><b>1:10</b>   |



- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



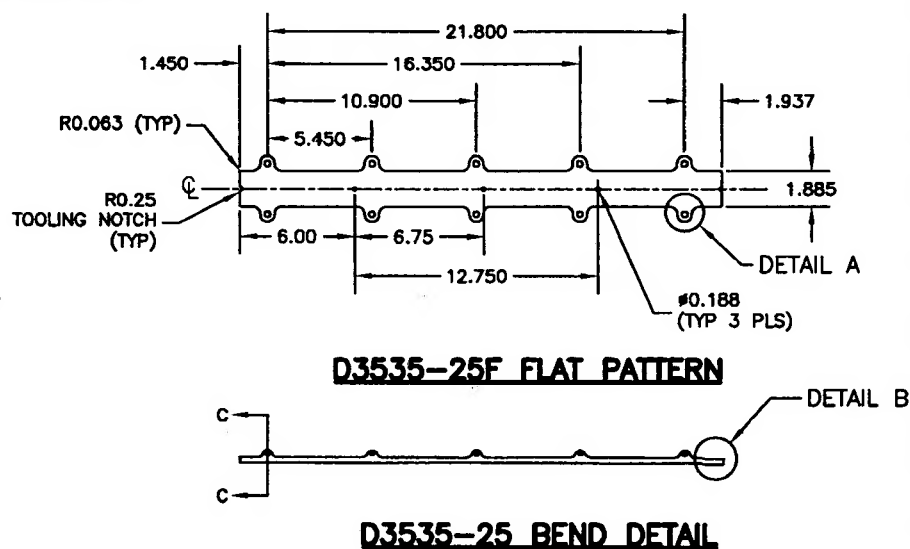
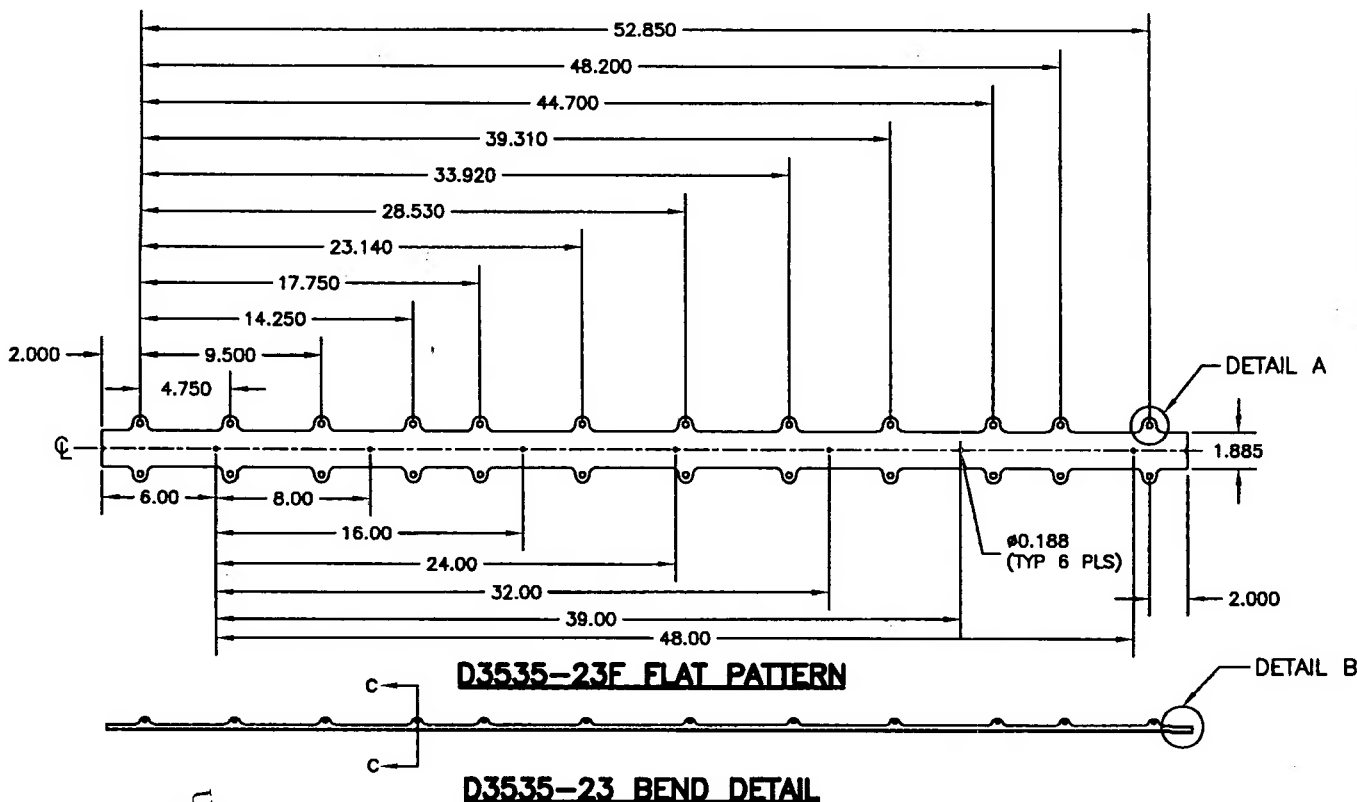
**D35.35-21 BEND DETAIL**

**DART**

RELEASED

07.04.24

|         |          |             |          |                          |
|---------|----------|-------------|----------|--------------------------|
| DESIGN  | CB       | DRAWN BY    | PH       | DART AEROSPACE USA, INC. |
| CHECKED | PH       | APPROVED    | PH       | PORT HADLOCK, WA         |
| DATE    | 07.04.17 | TITLE       | WEARSHOE | REV. B                   |
|         |          | DRAWING NO. | D3535    | SHEET 3 OF 7             |
|         |          | SCALE       | 1:10     |                          |



**NOTES**

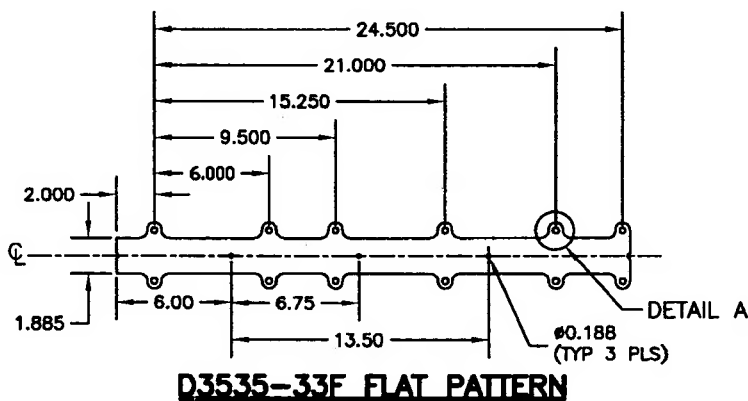
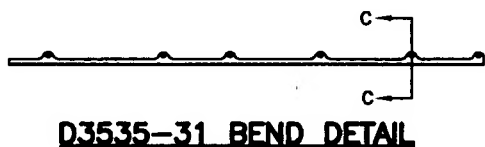
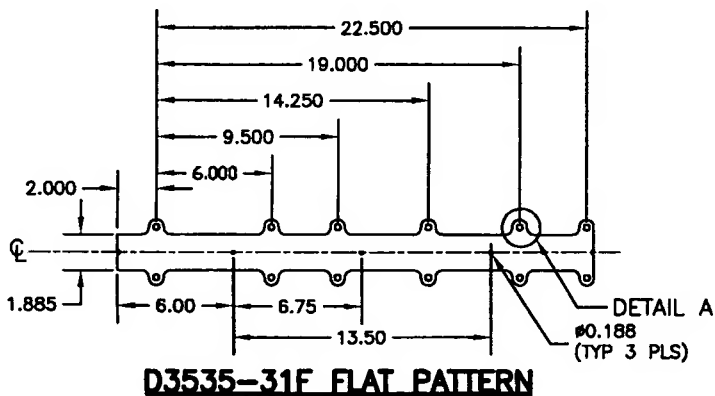
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33629

**DART**

|         |                    |             |                    |                          |
|---------|--------------------|-------------|--------------------|--------------------------|
| DESIGN  | CB                 | DRAWN BY    | PH                 | DART AEROSPACE USA, INC. |
| CHECKED | <i>[Signature]</i> | APPROVED    | <i>[Signature]</i> | PORT HADLOCK, WA         |
| DATE    | 07.04.17           | DRAWING NO. | D3535              | REV. B                   |
|         |                    | TITLE       | WEARSHOE           | SHEET 4 OF 7             |
|         |                    | SCALE       | 1:10               |                          |

RELEASED  
07.04.24



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33629

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

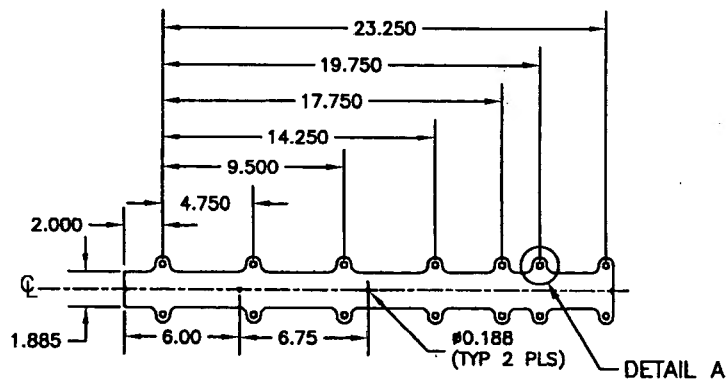


**DART**

RELEASED

07.04.17

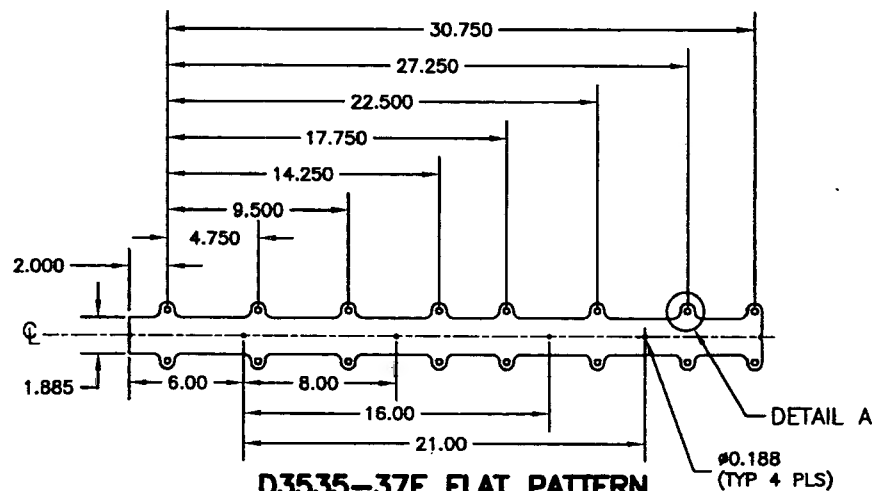
|         |          |             |          |                          |
|---------|----------|-------------|----------|--------------------------|
| DESIGN  | CB       | DRAWN BY    | PH       | DART AEROSPACE USA, INC. |
| CHECKED |          | APPROVED    |          | PORT HADLOCK, WA         |
| DATE    | 07.04.17 | DRAWING NO. | D3535    | REV. B                   |
|         |          | TITLE       | WEARSHOE | SHEET 5 OF 7             |
|         |          | SCALE       | 1:10     |                          |



**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

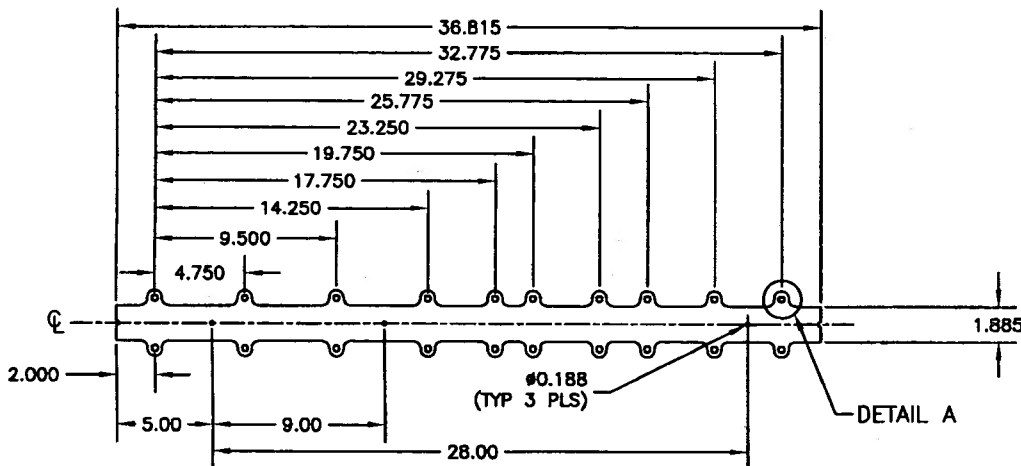
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33629

**DART**

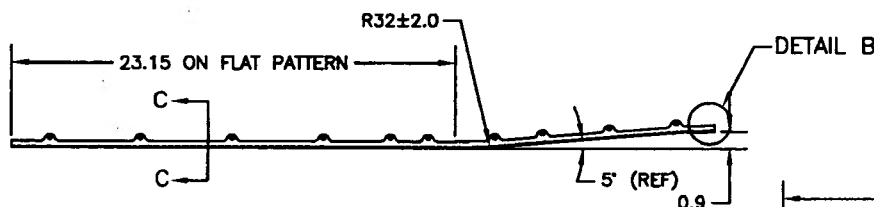
RELEASED

07.04.24

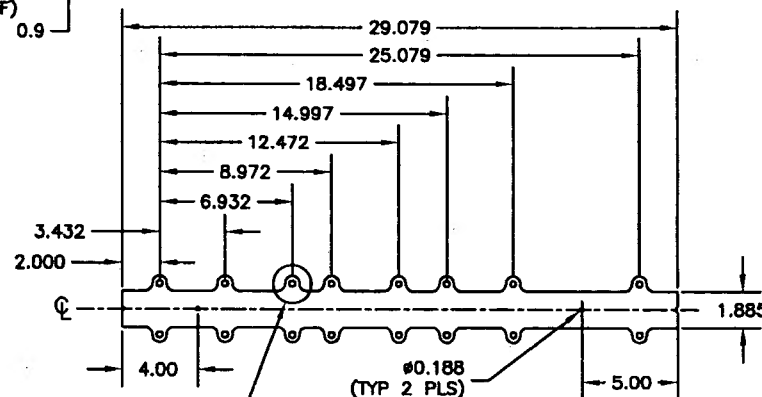
|         |          |             |          |                          |
|---------|----------|-------------|----------|--------------------------|
| DESIGN  | CB       | DRAWN BY    | PH       | DART AEROSPACE USA, INC. |
| CHECKED |          | APPROVED    |          | PORT HADLOCK, WA         |
| DATE    | 07.04.17 | DRAWING NO. | D3535    | REV. B                   |
|         |          | TITLE       | WEARSHOE | SHEET 6 OF 7             |
|         |          | SCALE       | 1:10     |                          |



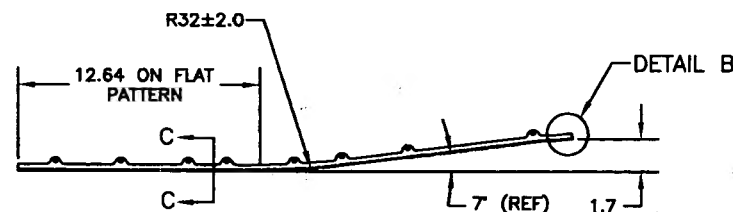
**D3535-39F FLAT PATTERN**



**D3535-39 BEND DETAIL**



**D3535-41F FLAT PATTERN**



**D3535-41 BEND DETAIL**

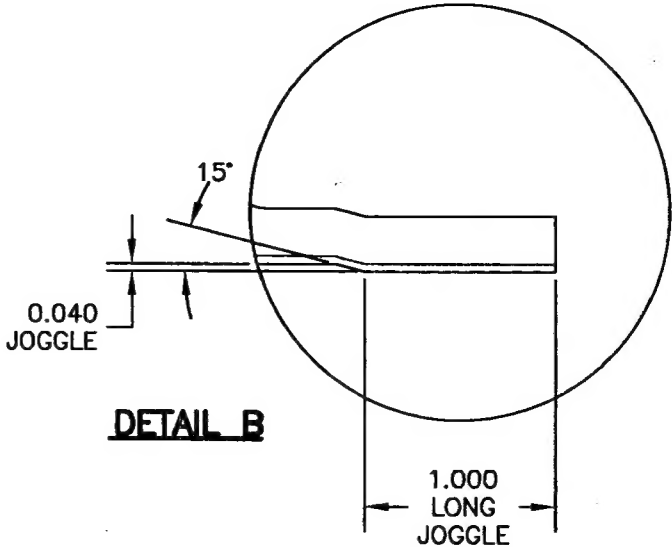
- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
  - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
  - 3) PART IS SYMMETRICAL ABOUT C
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
  - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
  - 8) SEE PAGE 7 FOR DETAILS AND SECTION

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 3629

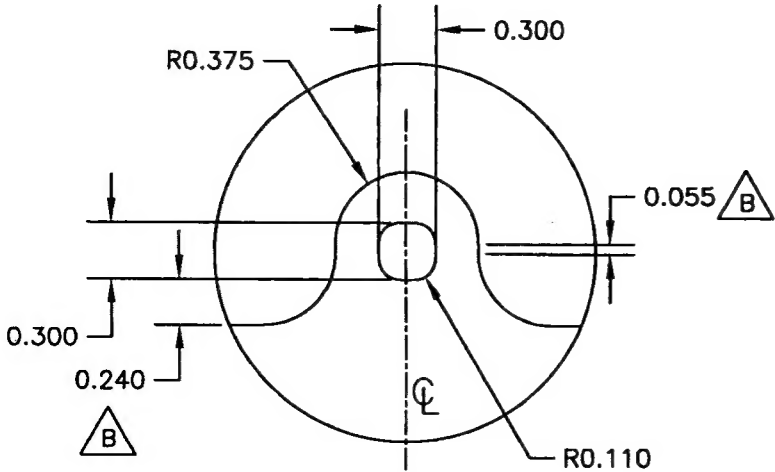
**DART**

|         |                    |          |                    |                          |
|---------|--------------------|----------|--------------------|--------------------------|
| DESIGN  | C.B.               | DRAWN BY | R.H.               | DART AEROSPACE USA, INC. |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | PORT HADLOCK, WA         |
| DATE    | 07.04.17           | TITLE    | D3535              | REV. B                   |
|         |                    |          |                    | SHEET 7 OF 7             |
|         |                    |          |                    | SCALE 1:1                |
|         |                    |          |                    | WEARSHOE                 |

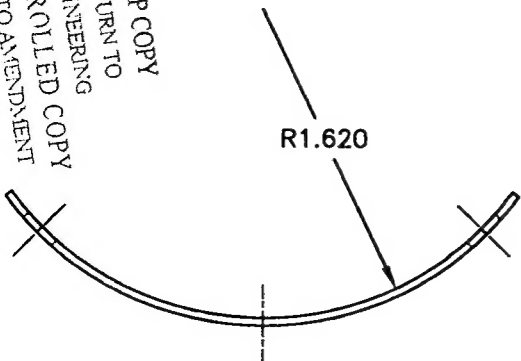
RELEASED  
07.04.24 *[Signature]*



**DETAIL B**



**DETAIL A**



**SECTION C-C**


SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 3629

|                        |        |                       |
|------------------------|--------|-----------------------|
| DART AEROSPACE LTD     |        | Work Order: 33629     |
| Description: WEAR SHOE |        | Part Number: D3535-39 |
| Inspection Dwg:        | Rev: B | Page 1 of 1           |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 36.815            | +/- .010      | 36.815           | X      |        |                      |          |
| 32.775            | +/- .010      | 32.775           | X      |        |                      |          |
| 29.275            | +/- .010      | 29.275           | X      |        |                      |          |
| 25.775            | +/- .010      | 25.775           | X      |        |                      |          |
| 23.250            | +/- .010      | 23.250           | X      |        |                      |          |
| 19.750            | +/- .010      | 19.750           | X      |        |                      |          |
| 17.750            | +/- .010      | 17.750           | X      |        |                      |          |
| 14.250            | +/- .010      | 14.250           | X      |        |                      |          |
| 9.500             | +/- .010      | 9.500            | X      |        |                      |          |
| 4.750             | +/- .010      | 4.750            | X      |        |                      |          |
| 2.00              | +/- .030      | 2.00             | X      |        |                      |          |
| 9.00              | +/- .030      | 9.00             | X      |        |                      |          |
| 1.885             | +/- .010      | 1.888            | X      |        |                      |          |
| 28.00             | +/- .030      | 28.00            | X      |        |                      |          |
| Ø .188            | + .005 - .001 | Ø .188           | X      |        |                      |          |
| Ø .300 x .300     | + .006 - .001 | Ø .303 x .303    | X      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                 |   |                     |
|-----------------|---|---------------------|
| Measured by: IB | Audited by:  | Prototype Approval: |
| Date: 07-07-21  | Date: 07/07/23  | Date:               |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |

